

Date: Monday, 07/07/2008 4:23:34 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HANDLE ASSEMBLY (EXTERIOR)		
Job Number	: 40348			Part Number	: D3779041		
Estimate Number	: 13371			Drawing Number	: D3779 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/07/2008 S.O. No. :			Drawing Revision	: A		
Prsh Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 28/07/2008		
Previous Run	: 05032			Qty:	10 Um: Each		
Written By	:			13			
Checked & Approved By	: JUL 08. 7.07						
Comment	: Est Rev:A 08-06-09 new issue DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S125	6061-T6 .125 Sheet
 Comment: Qty.: 0.2037 sf(s)/Unit Total: 2.0370 sf(s) 6061-T6 .125 Sheet batch: 106634 HB 8-7-14		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg D3779 Dwg Rev: A HB 8-7-14 Prog Rev: A (14)		
2-Deburr if necessary HB 8-7-14		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-14		
4.0	QC8	SECOND CHECK
 Comment: SECOND CHECK Cool(7/15) (+14) 8-7-14 (14) (PDS)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
 Comment: PACKAGING RESOURCE #1 Pick Packing Kit		

		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/07/21	4.1	countersink deburr	FF	08/07/23	14			
	4.2	QC 5	SL	08/07/25	14			
	4.3	Chemical Conversion Coat	FL	08/07/25	14	Initial	08/07/21	
	4.4	QC 3	SL	08-07-28	14			

Part No: D3779-041 PAR #: N/A Fault Category: Prod Eng Coordinating NCR: Yes No DQA: D Date: 08/10/23  
(D412-658-035)  
QA: N/C Closed: H Date: 08/10/24

		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
08/07/21	4.0	During QC 8 inspection it was found that the distance between the $\phi.315\text{-}\phi.323$ holes is 6.460" measuring 7.000"	OS10112	update <del>0.000</del> water jet and program according to Dwg. Rev. 1.0	08/07/15	OS10112			
		PL: Program on water jet was <del>not</del> not updated to the Dwg. D3779-1. Operator took Program from Print	OS10112	Scrap and Destroy and replace QH 14 B6 W6634	8-7-15	OS10112	OS10112	OS10112	

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:23:35 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HANDLE ASSEMBLY (EXTERIOR)
Job Number: 40348		Part Number: D3779041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D32031 	Handle Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Handle batch: 40353 <i>Psp/28 11</i>
7.0	MS20426AD10 18 	Rivet Countersunk Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s) Rivet Countersunk batch: M10736 448 <i>03779-041</i> or (MS20426AD10-10)
8.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 <i>1- counter sink holes as per dwg D3779 2- deburr 3- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003</i> <i>FF 08/10/22</i>
9.0	QC5 	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP <i>S08/10/22 07</i>
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: <i>100/23 0</i>
11.0	QC21 	FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE <i>08/10/23</i>
Job Completion 		<i>MF 08-10-23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40349
Description: HANDLE ASS'y (ETERIOR)	Part Number:	D 379-1
Inspection Dwg: D 379-1 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by: HB	Audited by: S	Prototype Approval: 1
Date: 8-7-15	Date: 08/07/15	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

$\int_{\Omega} \phi(x) u(x) dx$

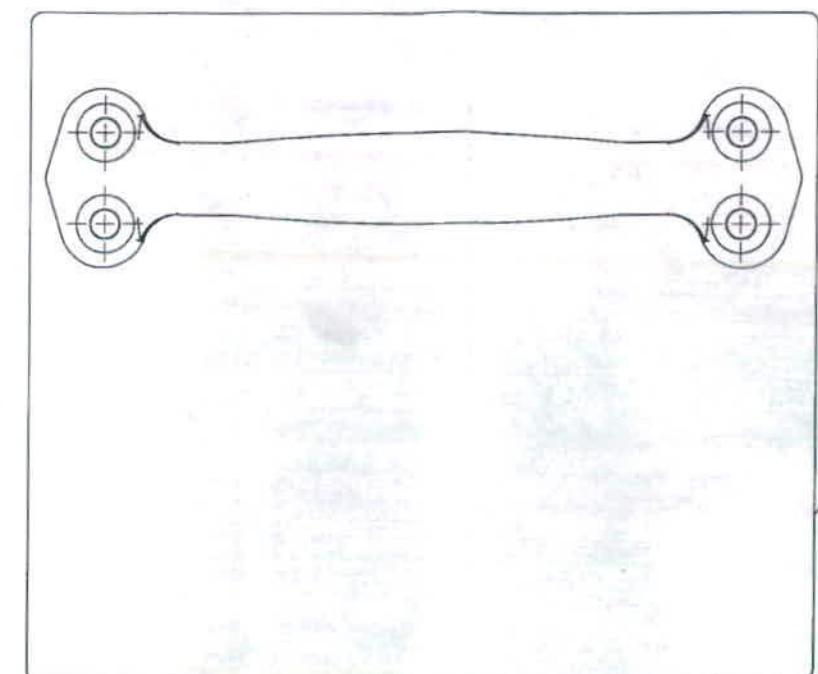
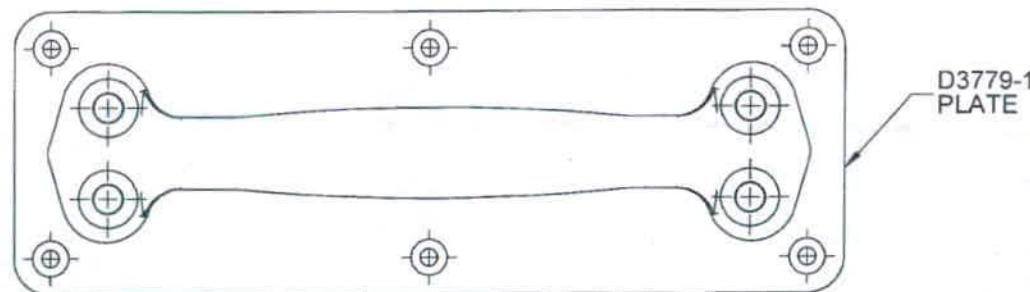
$\phi(x) u(x)$

$\phi(x) u(x) dx$

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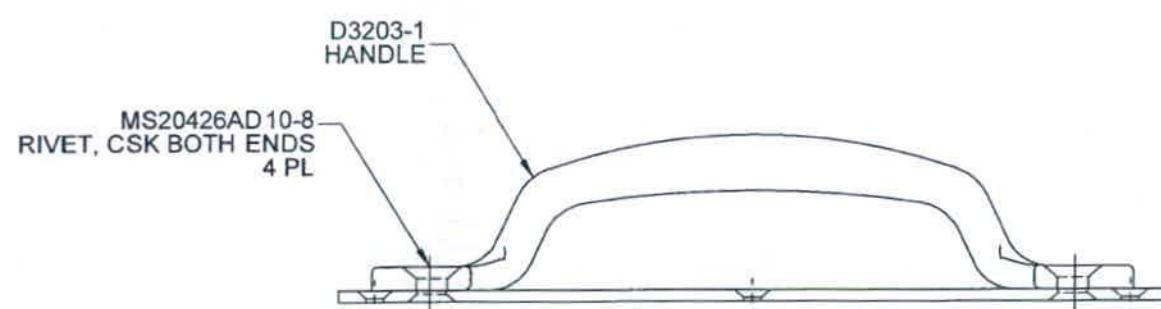
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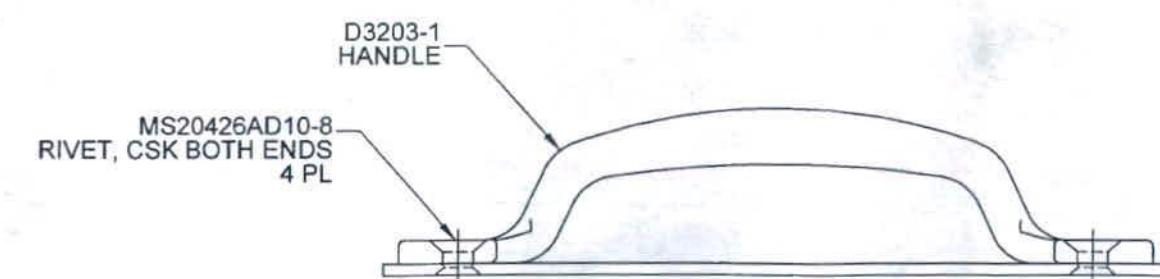


C

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D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY  
(INTERIOR)

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40348

RELEASED  
08-06-26 14:41

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3779	
MFG. APPR.		REV. A	
APPROVED		SHEET 2 OF 4	
DE APPR.		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DATE 08.04.21		SCALE NTS	

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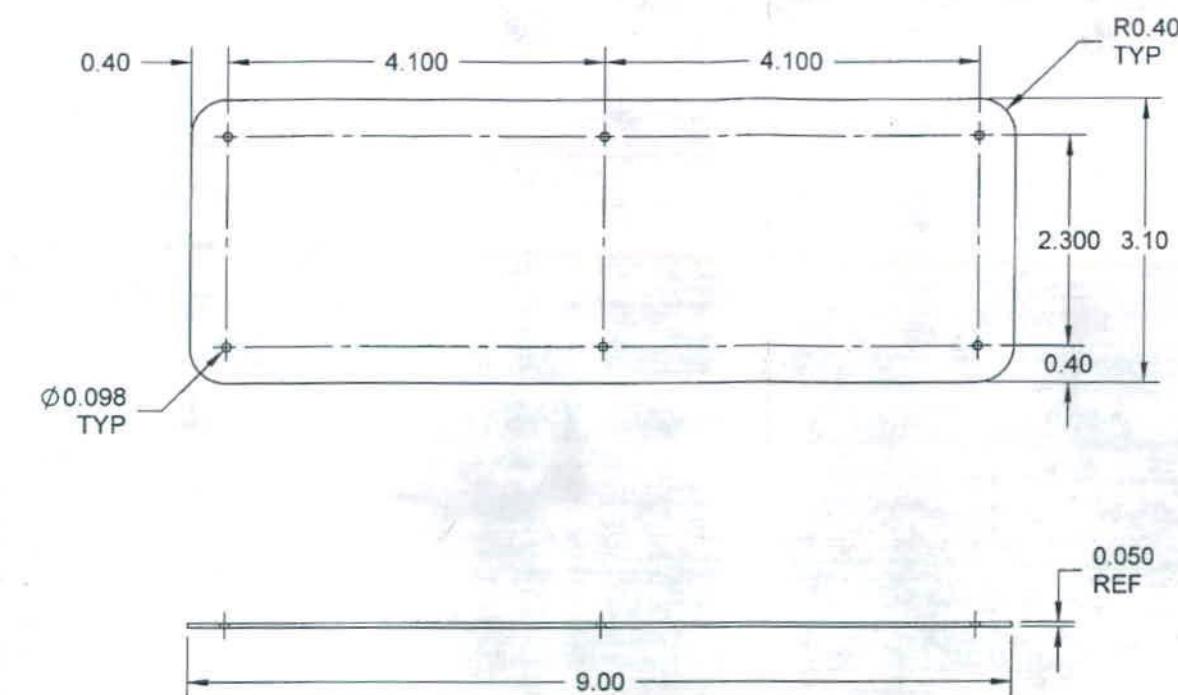
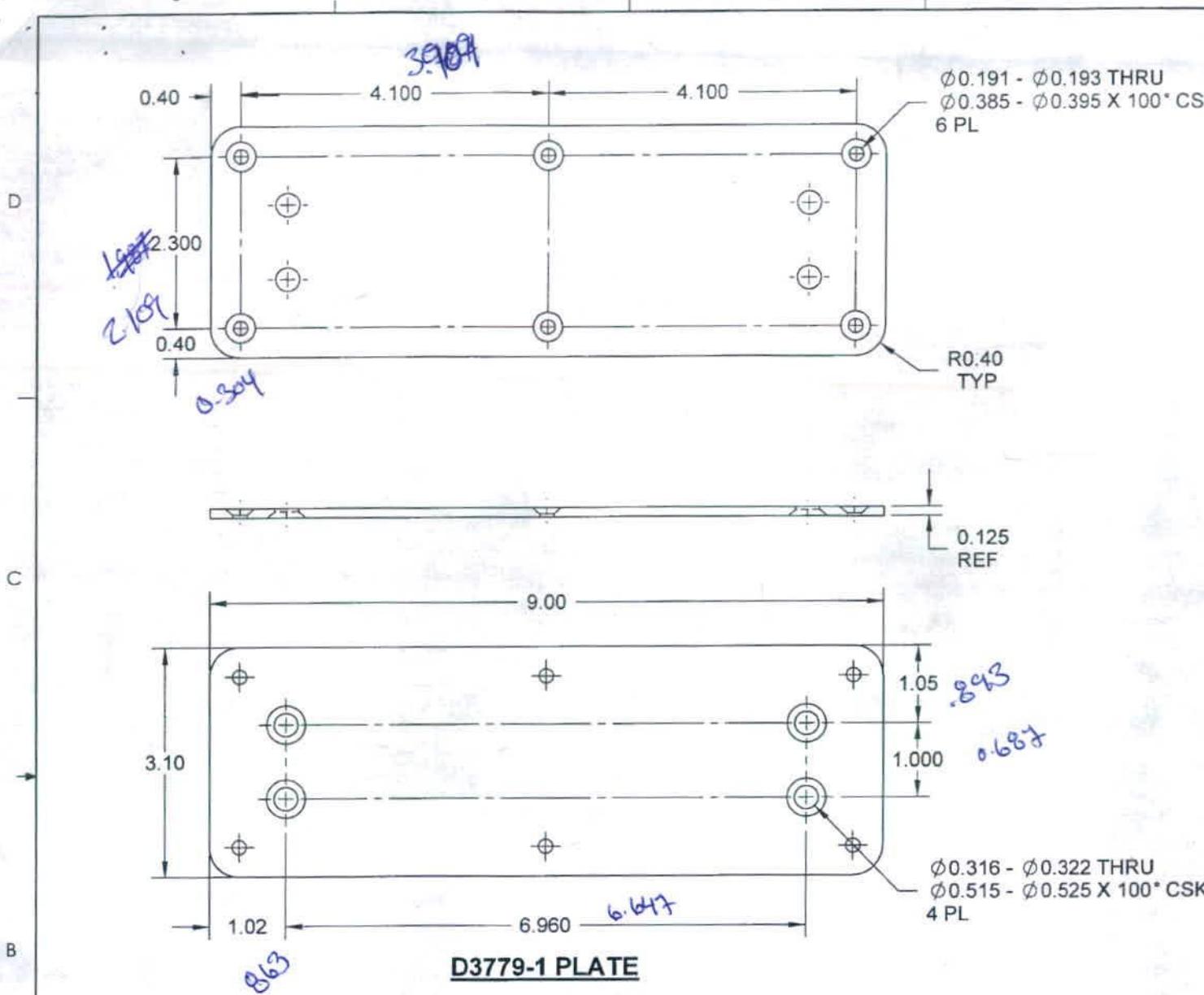
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A





**D3779-3 PLATE**

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WORK ORDER  
NO. 40348

**NOTES:**

NOTE: 1) MATERIAL -1 PLATE

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S 125

REF DART SPEC M8851163.12  
3 PLATE:

-3 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF. PART SPEC. M6061T6S-050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.

#### 5) BREAK SHARP EDGES: 0.005 TO 0.010 MM

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER  
(DO NOT IDENTIFY: 18-5)

(DO NOT IDENTIFY -1 & -5)

7) WEIGHT: 0.14 lbs FOR -3.

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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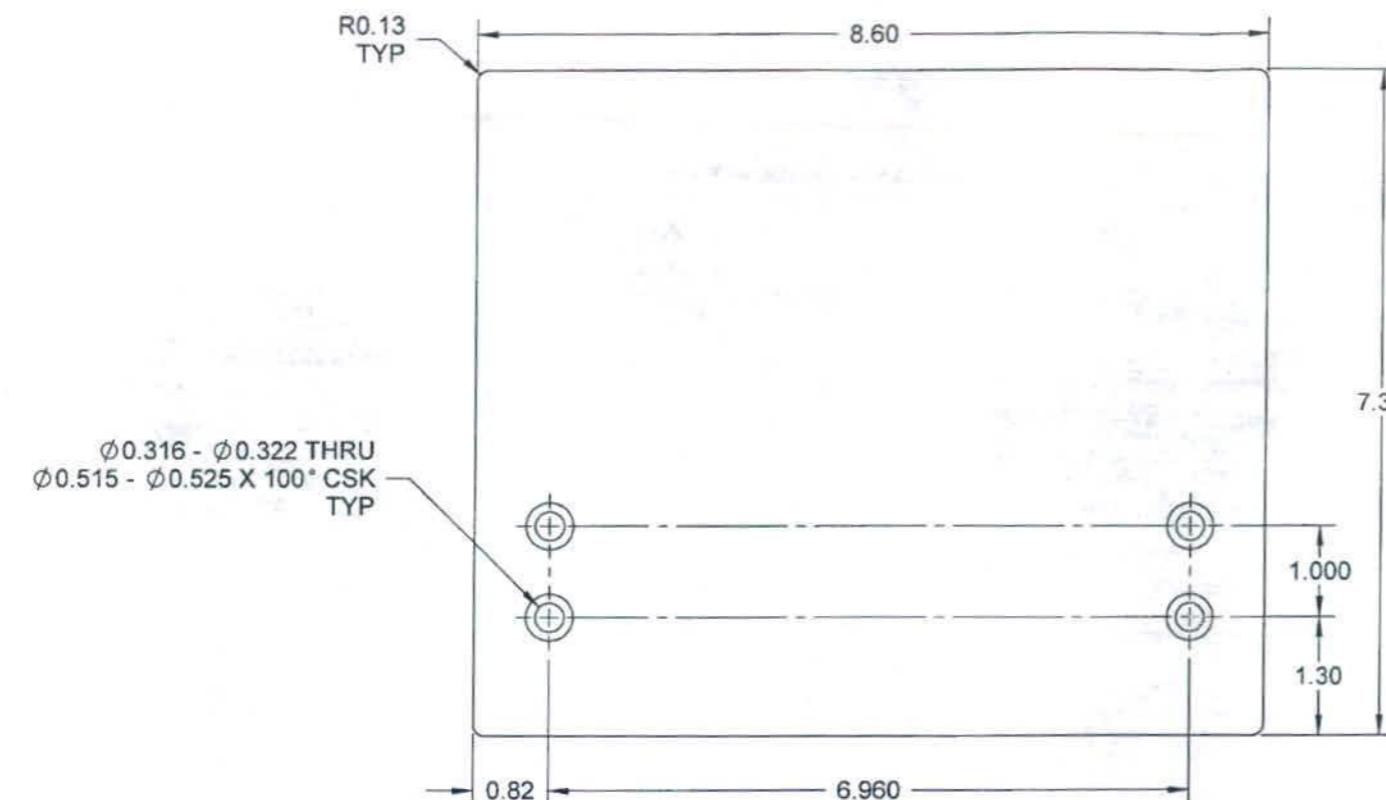
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8 7 6 5 4 3 2 1

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D



D3779-5 PLATE

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NO 40348

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08-06-26/14

NOTES:

- 1) MATERIAL: -5 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

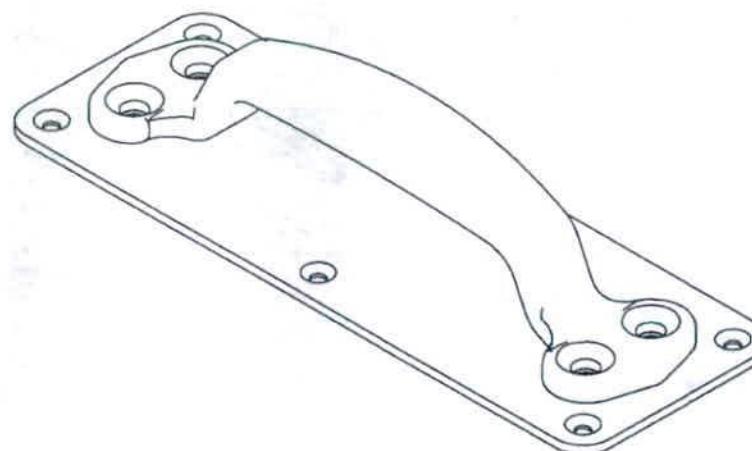
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DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	
MFG. APPR.	M	REV. A	
APPROVED	M	D3779	
DE APPR.	M	SHEET 4 OF 4	
DATE	08.04.21	TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	
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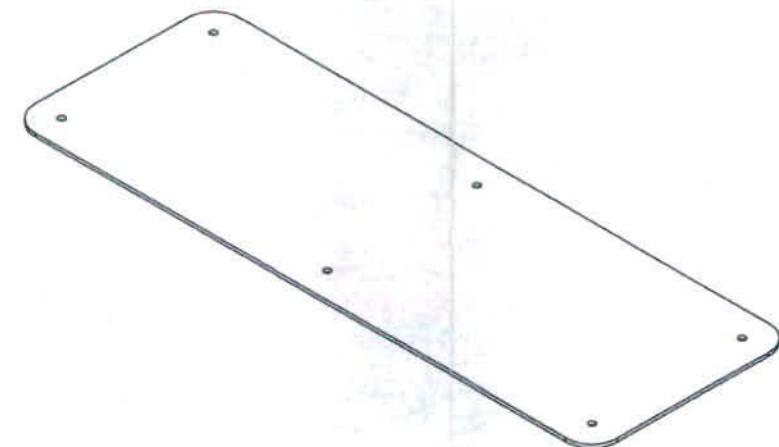


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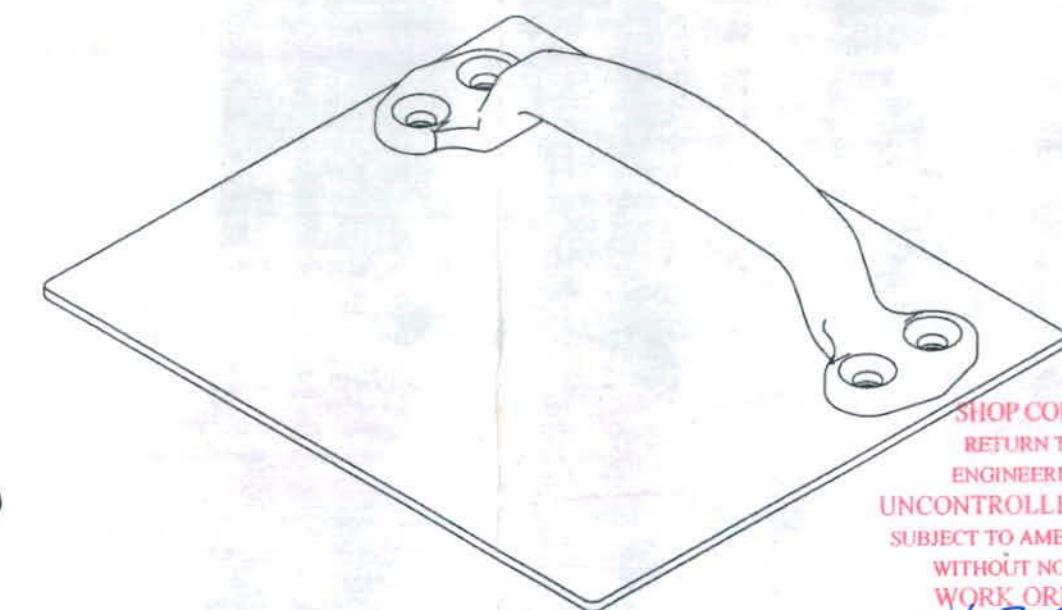
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)



D3779-3 DOUBLER PLATE



D3779-043 HANDLE ASSEMBLY  
(INTERIOR)

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DB 06.26.11

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A	NEW ISSUE	AJS	08.04.21	
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3779	SHEET 1 OF 4	
APPROVED		TITLE	HANDLE ASSEMBLY, CABIN SLIDING DOOR	
DE APPR.		SCALE	NTS	
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8 7 6 5 4 3 2 1

